

Work Order ID 62238

Wednesday, September 22, 2010 3:36:45 PM



Page 1

Item ID: D3564-9

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 9/22/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/29/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3564	Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ***** (D3564-1F) ***** ☐ Dwg Rev: D ☐ Prog

304.063

Rev: D ☐ 2-Deburr if necessary

1310-9-24

(15)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

1310-9-24

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

810/09/29

(15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62238

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Page 2

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Accept

Revision ID:

Item Name: Wearshoe

Start Date: 9/22/2010 Start Qty: 12.00

Required Date: 9/29/2010 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start _____
Stop _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
Brake NC	Memo	0.00							
Brake NC	Deburr if necessary <input type="checkbox"/> Form on Brake as per Dwg D3564 using Jigs DT 8129 and DT 8155 <input type="checkbox"/> Form Joggle as per Dwg D3564 on brake using Jig DT 8157								
140	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control	Ensure joggle as per dwg D3429								
150	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	Qty Description Batch <input type="checkbox"/> A/R 2059B Hardcoat								
	<input type="checkbox"/> Weld hardcoat as per Dwg D3564								

M115879

SB 10/09/30

15

15

1007-30

270

10/10/19

142

W/O: 62238

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.10.20	150	took one for corrosion test	U	10.10.20	1	U 10/10/20	

Part No: D3564-9 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

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Start Date: 9/22/2010 Start Qty: 12.00

Cust Item ID:

Required Date: 9/29/2010 Req'd Qty: 12.00


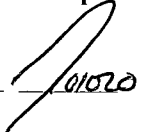

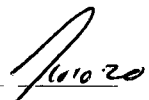

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				15			
170  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				15			
180  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>M.112588</i> Memo START TIME: <u>8:35</u> <u>3:20</u> FINISH TIME: <u>9:05</u>	0.00 0.00				15			<i>BR 10-10-22</i>

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Work Order ID 62238

Wednesday, September 22, 2010 3:36:45 PM

Page 4

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Revision ID:

Item Name: Wearshoe

Start Date: 9/22/2010 Start Qty: 12.00

Required Date: 9/29/2010 Req'd Qty: 12.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00

= 7 HU 10/10/22

15

0



QC

Memo

Quality Control

200

Identify as per dwg & Stock Location

0.00

FR-19 BR 10-10-22

15.



Packaging

Memo

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

10/10/22
SMF
10-10-22

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, September 22, 2010 3:36:49 PM

Page 1

Work Order ID: 62238

Parent Item: D3564-9

Parent Item Name: Wearshoe



Start Date: 9/22/2010

Required Date: 9/29/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-03-08 ec
 IPP Rev:B As per Rev C 07-07-09 JLM
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	160.8400	1.41	17.81053	19.8	21.	
304/316 Sheet .063											1316-9-29		

Location

Loc Qty

Loc Code

MAT

146.7

111323

0

115688

146.7

MAT20

14.14

115440

14.14

115688

15

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	62238
Description: Wearshoe		Part Number:	D3564-9
Inspection Dwg: D3564	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.225			V B02	
2.432	+/-0.010	2.439			V	
2.50	+/-0.030	2.50			V	
6.000	+/-0.010	6.000			V	
12.104	+/-0.010	12.104			T B01	
18.000	+/-0.010	18.000			T	
18.000	+/-0.010	18.00			T	
18.00	+/-0.030	18.00			T	
9.00	+/-0.030	9.00			T	
11.50	+/-0.030	11.50			T	
0.300 x 0.300	+/-0.010	0.300x0.301			V	
Ø0.188	+0.005/-0.001	0.190			V	
R0.375	+/-0.010	0.375			R.G.	
0.063	+/-0.010	0.059			V	

Measured by: <i>RB</i>	Audited by: <i>S</i>	Prototype Approval:	N/A
Date: 10-9-29	Date: 10/09/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD <i>AF</i>	<i>DB</i>

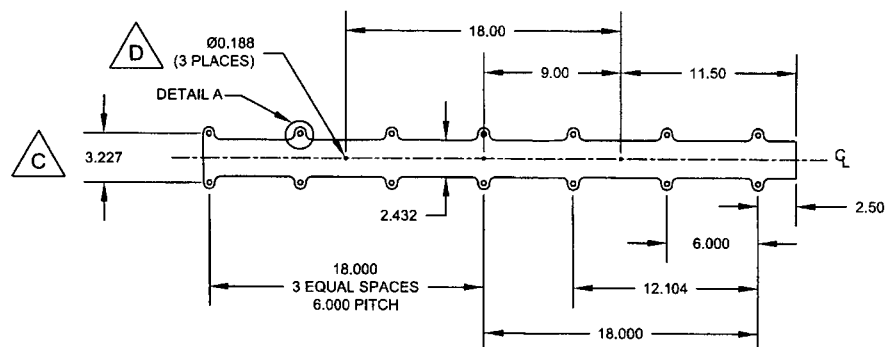
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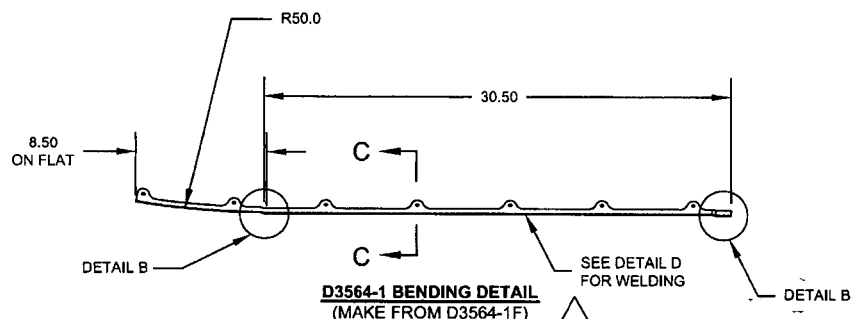
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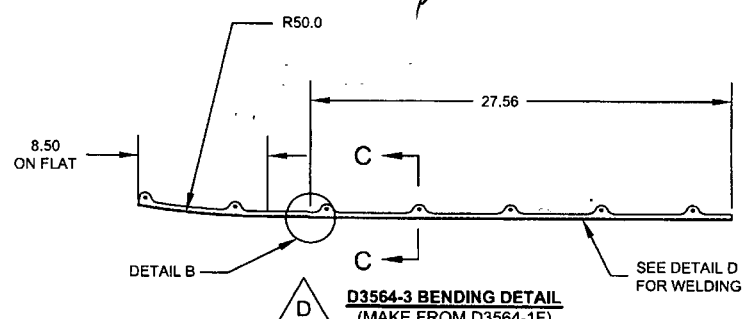
D3564-1F FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *62238*
10-9-22

RELEASED
07.09.04 *H*



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE		CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A		PH	07.04.17
B	ADD AMS 5513 AND AMS 5524		PH	07.03.20
A	NEW ISSUE		PH	06.12.18
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3564 TITLE WEARSHOE SCALE 1: REV. D SHEET 1 OF 3 COPYRIGHT © 2006 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		
DRAWN	CB			
CHECKED	PH			
MFG. APPR.	PH			
APPROVED	PH			
DE APPR.	PH			
DATE	07.08.21			

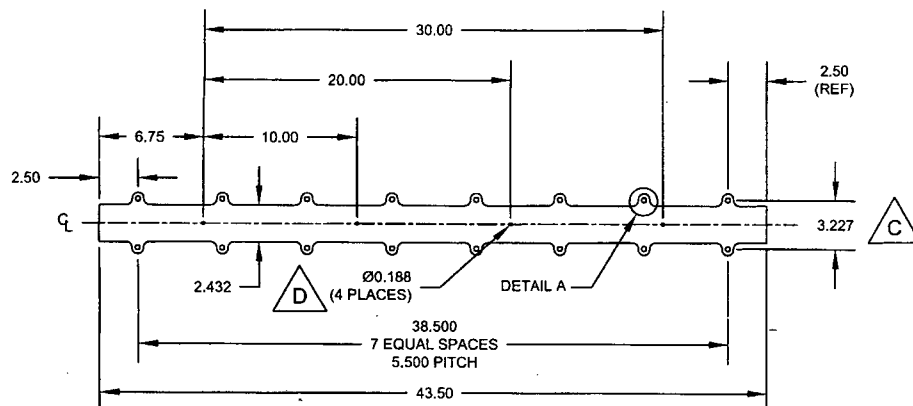
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

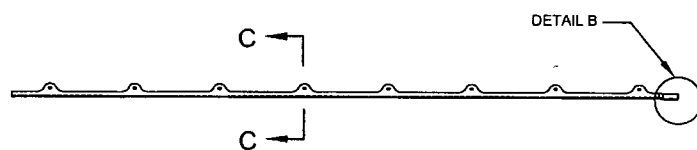
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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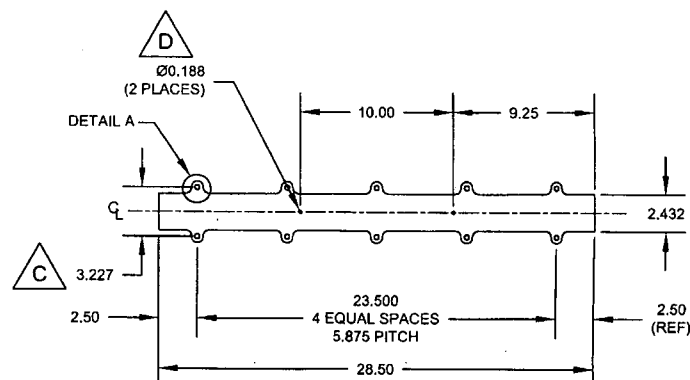
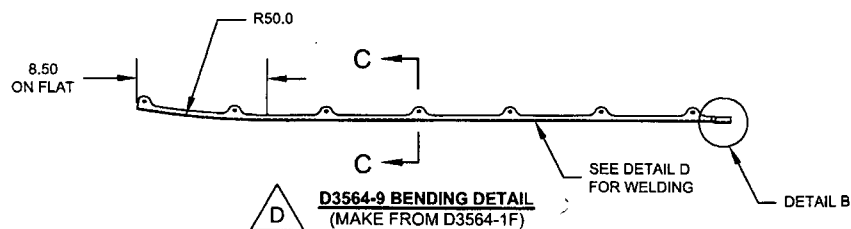
NOTE: Date & initial all entries



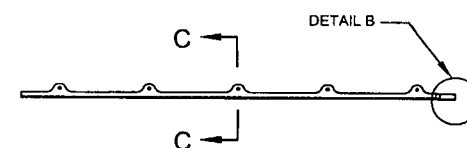
D3564-5F FLAT PATTERN



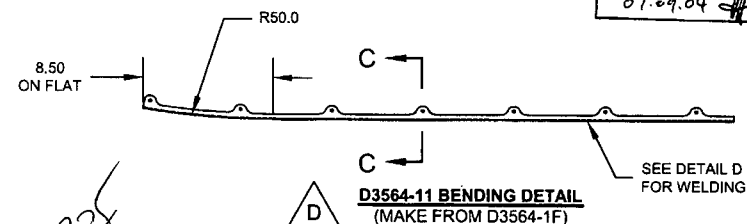
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



RELEASED

07-09-04

w/o 48235

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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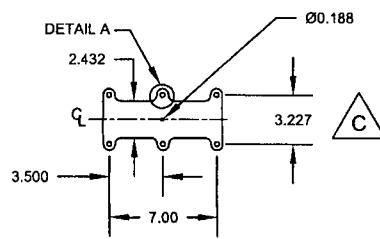
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

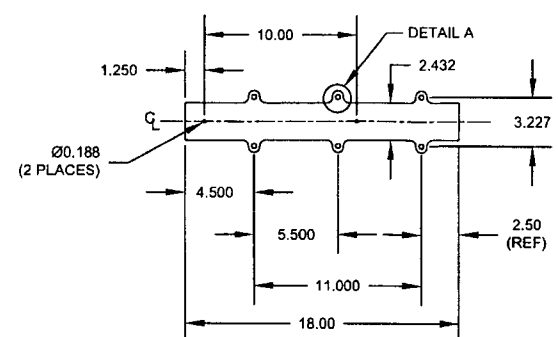
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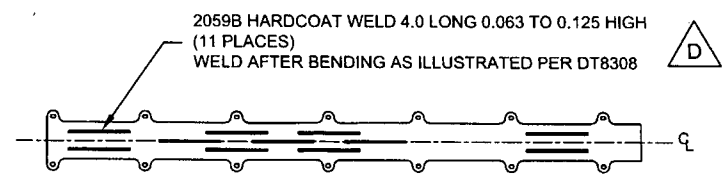
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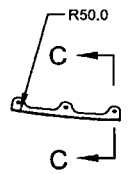
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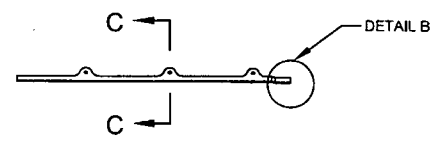
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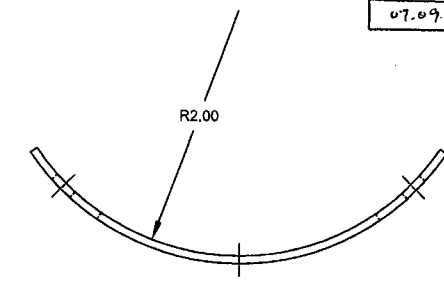
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)

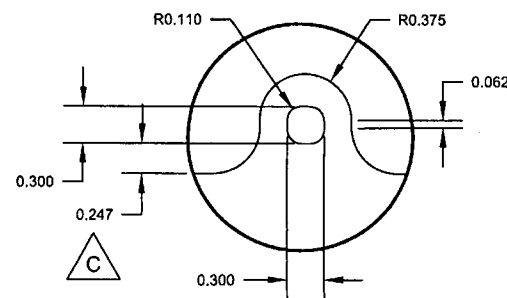


D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)

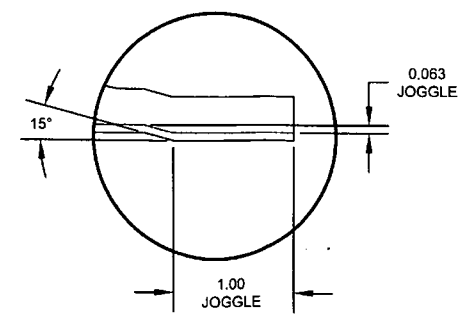


SECTION C-C
SCALE 1:1

RELEASED
07.09.04



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

u/o 62238

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DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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8 7 6 5 4 3 2 1

D

C

B

A

D

C

B

A

W/O:		WORK ORDER CHANGES					
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